

5/20

Sprint

DART AEROSPACE LTD	Work Order:	22959
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2 RF 03.02.17 RF 03.02.28	Qty:	100 48

Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg. not required RF 02.11.04 (Minimum lots of 30)	PF	05.04.13	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") M17347 Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick 30204 (M2024T3S.040) Batch M16548 Identify as D3065-1 4.320" RF 02.11.29 4.320"	PF	05/04/20	60 PTO
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") 4.250" RF Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick 02.11.29 (M2024T3S.040) Batch M16548 Identify as D3065-3 M17347	PF	05/04/20	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch M17347 Identify as D3065-7	PF	05/04/20	60
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M15673 Identify as D3065-5 M17124 (Note: make 2 legs per assembly)	PF	05/04/20	120
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch M17124 Identify as D3066-1 (Note: make 2 spacers per assembly)	PF	05/04/20	120
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	SD	05.04.20	60
8	MV	Deburr to take measurement	SD	05.04.20	60
9	QC2	Inspect parts as they come off the CNC machine	SD	05.04.20	60
10	QC8	Second check	ER	05/04/21	60
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	SD	05.04.20	66
12	MV	Deburr to take measurement	SD	05.04.20	60
13	QC2	Inspect parts as they come off the CNC machine	SD	05.04.20	66
14	QC8	Second check	ER	05/04/21	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	SD	05.04.20	60
16	MV	Deburr to take measurement	SD	05.04.20	60
17	QC2	Inspect parts as they come off the CNC machine	SD	05.04.20	60
18	QC8	Second check	ER	05/04/21	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	/	/	/

05.03.09
HHD

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr.	Action Description Design Mgr	Sign & Date			
05-05-30	7	Noticed during Step 28. D3065-1 stock is not machined on one side. 0.035" over tolerance of 0.010". 8 scrap because they're bent & over tolerance.	<i>John</i> <i>Wright</i>	Grind .030" off edge of remaining 7 D3065-1.	SB 05/05/30	<i>John</i> 05-05-30	<i>John</i> Wright	<i>John</i> 05-05-30
05/05/31	28	D 3065-1 4 scrap D 3065-7 1 scrap D 3065-3 1 scrap Bend were bent over tolerance	<i>John</i> <i>Wright</i>	Scrap & destroy	SB 05/05/31	<i>John</i> 05-05-31	<i>John</i> Wright	<i>John</i> 05-05-31
05/06/07	31	11 D 3065-7 5.78 26 D 3065-3 6.01 20 D 3065-5 5.31	<i>John</i> <i>Wright</i>	I identify & stock	SB 05/06/07	<i>John</i> 05-06-07	<i>John</i> Wright	<i>John</i> 05-06-07

Part No: D3065-041

PAR #: _____

Fault Category: Prod / Machined

Part
NCR:

Yes

No

DQA:

John

Date: 05/07/05

NOTE: Date & initial all entries

QA: N/C Closed:

Date: 05/07/05

DART AEROSPACE LTD

Work Order:

22959

Description: Hi - Step Leg Assembly

Part Number:

D3065-041

RF 03.02.28

Dwg: D3065 Rev. A1 A2

Qty:

RF 03.02.28

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Step	Location	Procedure	By	Date	Qty
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	En	05/04/22	120
20	MV	Deburr to take measurement	En	05/04/22	120
21	QC2	Inspect parts as they come off the CNC machine	En	05/04/22	120
22	QC8	Second check	En	05/04/22	120
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	En	05/04/22	120
24	MV	Deburr to take measurement	En	05/04/22	120
25	QC2	Inspect parts as they come off the CNC machine	En	05/04/22	120
26	QC8	Second check	En	05/04/22	120
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack. 3939 50 67 43 67	ML	05/05/26	X PTO
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065 48 74 59	ML	05/05/01	48 PTO
29	QC5	Inspect work to Step 28	2	05-06-01	48 PTO
30	FP	Chemical conversion coat as per QSI 005 4.1 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	FF	05-06-01	48 PTO
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly.			
		Qty Part Number Description Batch			
		1 D3065-1 Spacer B 22959			
		1 D3065-3 Spacer B 22959			
		2 D3065-5 Leg B 22959			
		1 D3065-7 Spacer B 22959			
		30 MS20470AD4-4 Rivet M 15829			
32	QC5	Inspect work to Step 31	2	05-06-03	48
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer 5.19	DD	05-06-20	120
34	AC	Cost / part 34.35	SP	05-06-07	120
35	DC	Close W/O 35.05 Inspect Level 21	SP	05-07-04	120
			SP	05-07-05	48

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-05-20	19	4x D3065-5 no good. Vertical dimension under tolerance. Rivet holes to close to the edge. blanks cut too short.					

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-20	# 11	one stack (15) scrap D3065-3 Drill Broke	BB jerry5/20	Destroy & Replace stack of 15	SD 05-05-17	BB 05-05-21	BB jerry5/21	BB 05-05-21
05-05-20	27	Found in Basket Some pieces without holes	BB jerry5/20	Destroy 160 x D3065-7 128 x D3065-1 CNC Re-do the holes	SD 05-05-20	W	BB 05-05-20	BB 05-05-20
05-05-20	19	4x D3065-5 no good. Vertical dimension under tolerance. Rivet holes to close to the edge. blanks cut too short.	BB jerry5/20	Scrap & destroy	SD 05-05-30	SD 05-05-30	BB jerry5/20	SD 05-05-30

Part No: D3065-041

PAR #: _____

Fault Category: Prod / machined partsNCR: Yes NoDQA:

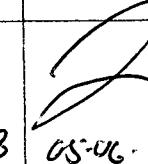
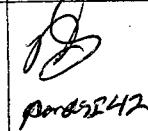
Date: 05/07/20

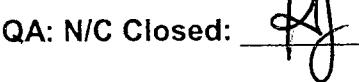
NOTE: Date & initial all entries

QA: N/C Closed: KJ

Date: 05/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22959		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-13	32	Deep scratch in material for D3065-5 leg	 paras242	replace with left over D3065-5 part, re-pivot leg assembly	SB 05/06/13	 05-06-13	 paras242	 05-06-13

Part No: D3065-041 PAR #: _____ Fault Category: Production ^{Kerb. 155' med & small} NCR: Yes No DQA:  Date: 05/07/05
 NOTE: Date & initial all entries QA: N/C Closed:  Date: 05.07.05

D3065-5DART AEROSPACE LTD	Work Order:	22959
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>SD</u>	Audited by: <u>EG</u>	Prototype Approval: <u>N/A</u>
Date: <u>05.04.20</u>	Date: <u>05.04.20</u>	Date: <u>03.10.08</u>

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/o D3065-041	KJ/RF

RELEASED
03.10.08 

D3065-5DART AEROSPACE LTD	Work Order:	22959
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Er	Audited by:	JNL	Prototype Approval:	N/A
Date:	05/04/21	Date:	05/04/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	

RELEASED

10/04.017

D3065-5DART AEROSPACE LTD	Work Order:	22959
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	EP	Audited by:	ML	Prototype Approval:	N/A
Date:	05/04/21	Date:	05/04/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	

RELEASED

H:\FORMS\Quality Assurance\approved QA\FAI revD

D3065-5DART AEROSPACE LTD	Work Order:	22959
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SD	Audited by:	ES	Prototype Approval:	N/A
Date:	05/04/20	Date:	05/04/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	

RELEASED

RELEASED
04-06-27.

D3065-5DART AEROSPACE LTD	Work Order:	22959
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	EP	Audited by:	97%	Prototype Approval:	N/A
Date:	05/04/21	Date:	05/04/22	Date:	03.10.08

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/o D3065-041	KJ/RF	TT

RELEASED
03.10.08

Job Costing Report

Dart Aerospace Ltd.
HawkesburyApr 11, 2005
07:31 am

Work Order No : 0022959
 Project Name : D3065-041
 Project For : WK520
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3065-041
 Description : Step Leg Assembly
 Manufactured : Yes
 Amount Req'd : 60
 Amount Done : 0
 Start Date : 04-08-05
 Est Finish Date : 05-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00